

ABSTRACT

In a 360-degree toothbrush in which a brush head is formed by superposing disk-shaped radial vanes 1 in an axial direction, the arranging pitch of the radial vanes 1 is increased so as to make the bristle density appropriate. Spacers are not used between the radial vanes 1 so as to increase the productivity, and to improve the hygiene condition. In order to realize these aspects, an annular protrusion or protrusions 3 are formed on one or both of the surfaces of an annular weld portion 2 of the radial vane 1. The annular protrusion 3 is formed at the same time when forming the weld portion 2 in a welding step in which the bristle bundle is opened radially and the center part is welded so that the radial vane 1 is manufactured.